

Date: Monday, 6/25/2007 9:09:52 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	WEARPLATE
Job Number	33105			
Estimate Number	10288			
P.O. Number	N/A		Part Number	D25771
This Issue	6/25/2007	S.O. No.	Drawing Number	D2577 REV E
Prsht Rev.	NC		Project Number	N/A
First Issue	N/A	Type	Drawing Revision	E
Previous Run	33055		Material	N/A
Written By			Due Date	7/10/2007
Checked & Approved By	<i>JRF 07.06.25</i>		Qty:	30
Comment	Um: Each Est: E 02.09.24 Re-format; Incorporated D2577-101/11 K J/RF est F 06.09.11 now waterjet EC			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010\$16GA	1010/1025/A21/6aA SHEET  m104048 m103433 (4)
 <b>Comment: Qty.: 0.8474 sf(s)/Unit Total: 25.4205 sf(s)</b> <b>1010/1025/A21/6aA SHEET m104048 (26) 1B 07-07-23</b>		
2.0	WATER JET	FLOW WATER JET    <b>Comment: FLOW WATER JET</b> 1-Cut as per Dwg D2577 (D2577-101 detail) Dwg Rev: <u>F</u> Prog Rev: <u>F</u>  <b>2-Deburr if necessary</b> <i>1B 07-07-23</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE    <b>Comment: INSPECT PARTS AS THEY COME OFF MACHINE</b> <i>1B 07-07-23</i>
4.0	QC8	SECOND CHECK    <b>Comment: SECOND CHECK</b> <i>5 07/07/24</i>
5.0	BRAKE NC	NC BRAKE    <b>Comment: NC BRAKE</b> 1-Form on brake as per Dwg D2577 using DT8155 and DT8179 2-Form joggle as per Dwg D2577 using DT8157 3-Identify as D2577-1 4-Deburr if nesasary — <i>m107/07/30 x30</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 0105/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 6/25/2007 9:09:52 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 33105

Part Number: D25771

Job Number:



Seq. #: Machine Or Operation:

Description:

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/01 X302577-1

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using DT8308A & DT8308B as per Dwg D2577

Qty Description  
A/R 7560 Hardcoat Rod

Batch  
M104855 M105465

FC 07/09/17 30

8.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

M07/09/17 30

9.0 POWDER COATING

POWDER COATING



M105642



30X

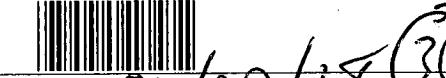
Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-f 07/09/18

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

F2 07/09/18 30

11.0 PACKAGING 1

PACKAGING RESOURCE #1



30X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

F-P 14

m-f 07/09/18

12.0 QC21

FINAL INSPECTION/W/O RELEASE



30

Comment: FINAL INSPECTION/W/O RELEASE

R 07/09/18

Job Completion



W 07/09/19

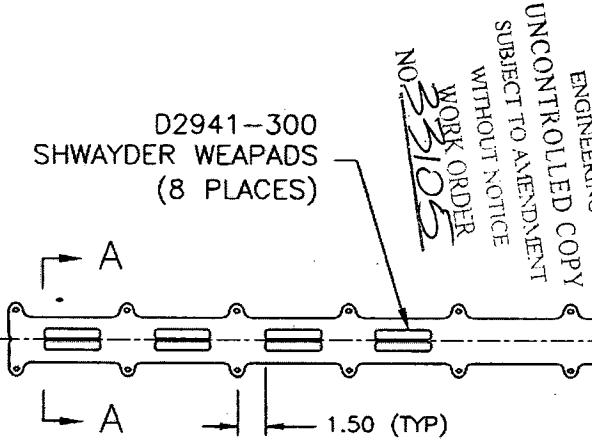
7560 HARDCOAT WELD  
4.0 LONG  
0.063 TO 0.125 HIGH  
(TYP. 11 PLS.)  
WELD AFTER BENDING AS  
ILLUSTRATED PER DT8308



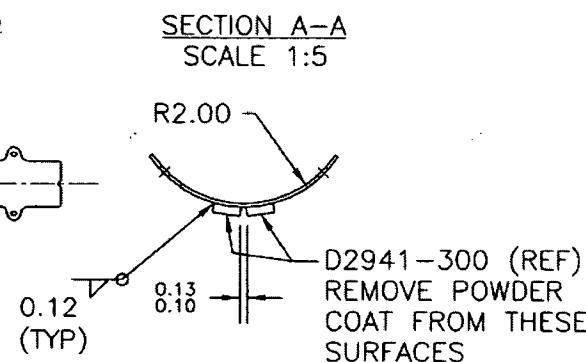
### D2577-1 & D2577-3 WEARSHOE

MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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### D2577-21 & D2577-23 WEARSHOE

MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY

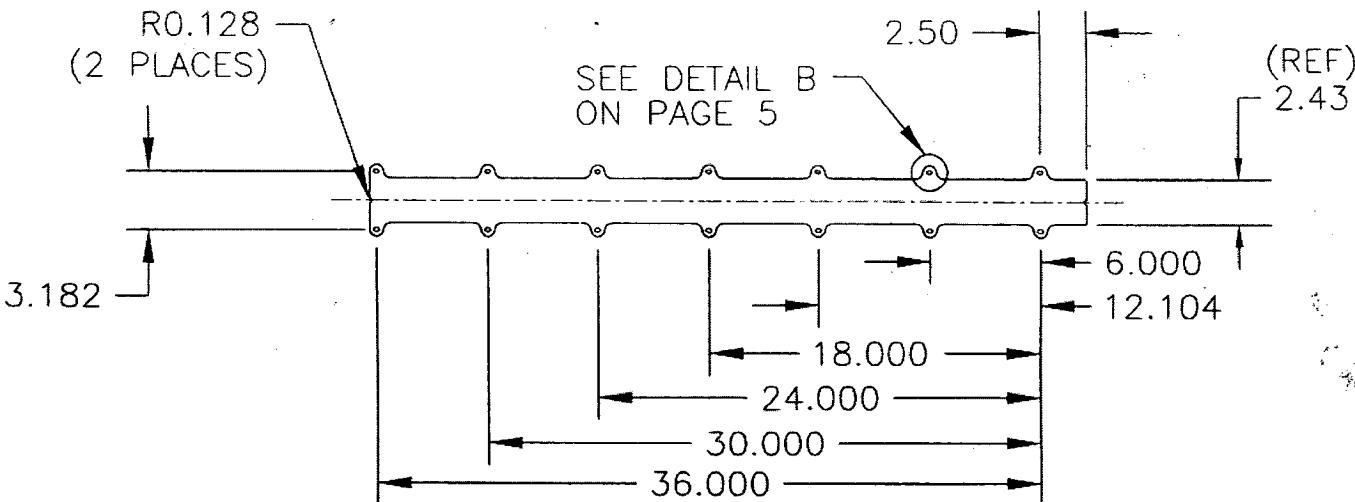
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**DART**

*QA CO*  
*Parry Sound*

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<i>[Signature]</i>	<i>[Signature]</i>	D2577
00.09.22		WEARSHOE
A	96.09.16	NEW ISSUE
B	96.12.04	ADD HARDCOAT WELDS
C	97.05.30	CHANGE HOLES TO OBROUNDS
D	98.08.17	CORRECTED DIMENSIONS ON -1 & -3
E	00.09.22	ADD D2577-101/-11/-13 INCORPORATE DE09176

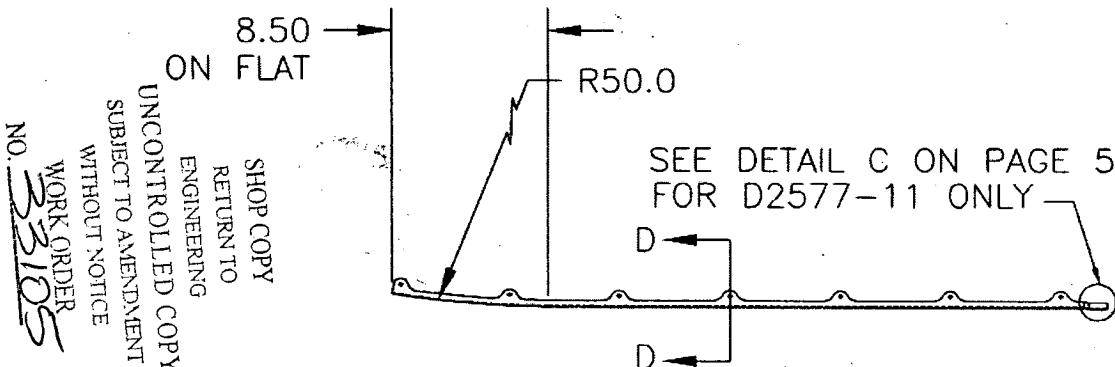


D2577-101 FLAT PATTERN

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570  
SERIES STEEL 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2577-11 & D2577-13 LONGITUDINAL BEND

MAKE FROM D2577-101

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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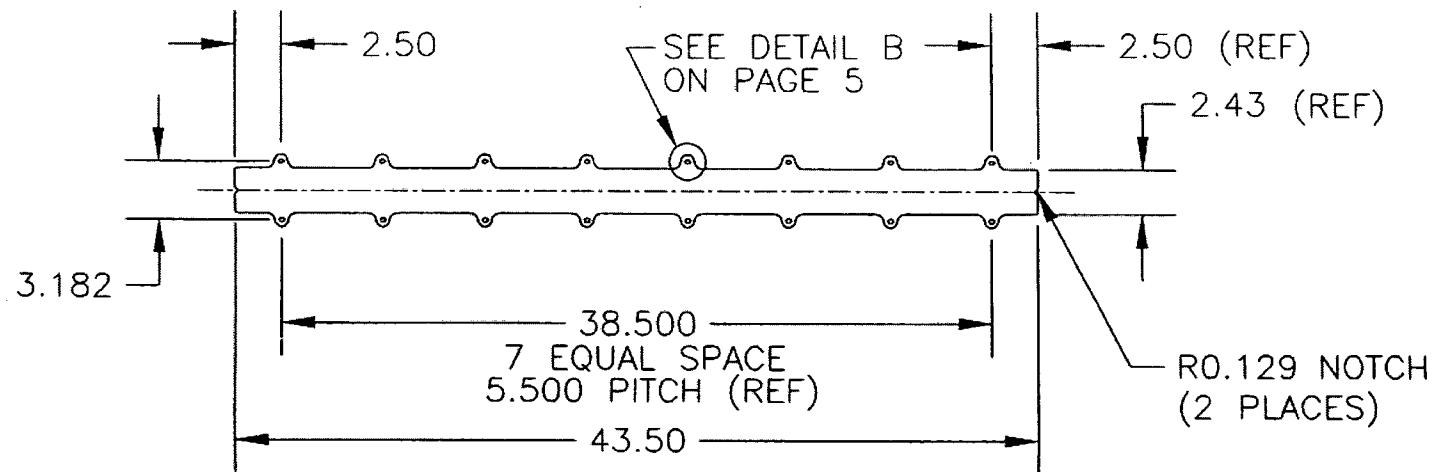
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00.09.22		WEARSHOE

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09.09.26  
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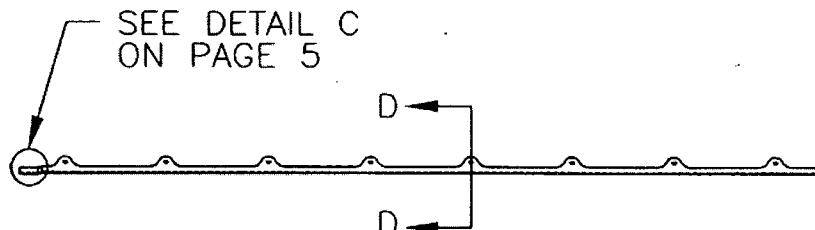
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D2577-5 FLAT PATTERN



D2577-5 LONGITUDINAL BEND



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D2577-5 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570  
 SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3  
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**DART**

Aero  
Corps  
1996

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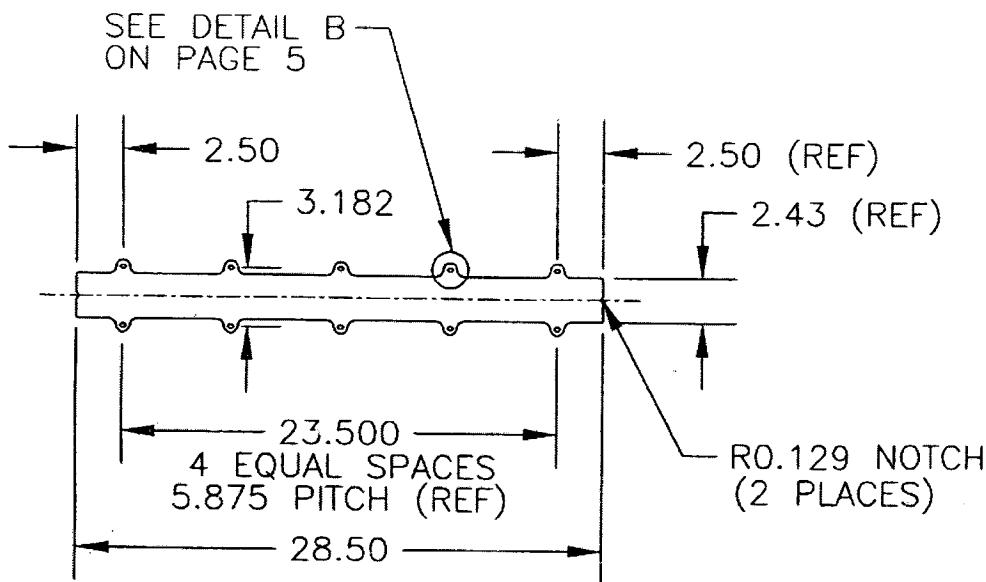
REV. E  
 SHEET 3 OF 5  
 SCALE  
 1:10

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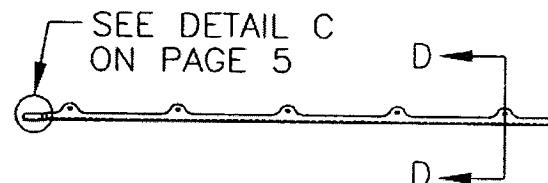
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### D2577-7 FLAT PATTERN



### D2577-7 LONGITUDINAL BEND



### D2577-7 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570  
SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3  
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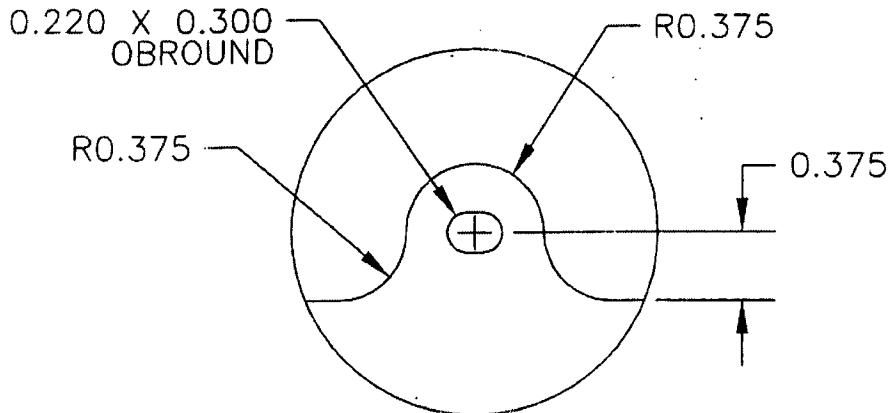
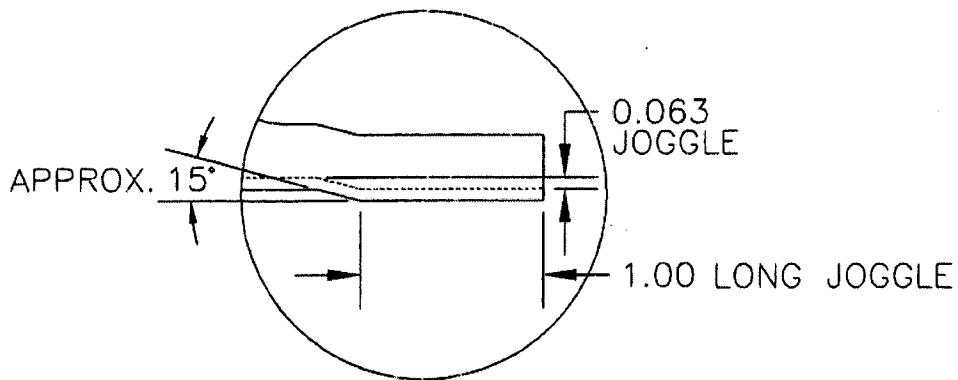
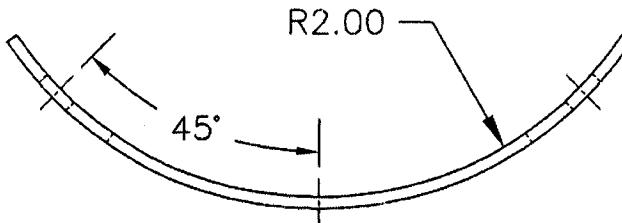
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DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10

DETAIL B (SCALE 1:1)**RELEASED**  
00.09.26 *[Signature]*DETAIL C (SCALE 1:1)SECTION D-D (SCALE 1:1)

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